

Date: Friday, 9/21/2007 1:19:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 34829	
Estimate Number : 10008	
P.O. Number : <i>N/A</i>	Part Number : D2591
This Issue : 9/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2591 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/21/2007 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 33568	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>90</i> Um: Each
Comment : Est Rev:1 Removed from 9 Digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s)
 ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)
 Batch: *14105801*

2.8 07/10/19

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.700" long

2.8 07/10/19

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

Machine per drawing D2591 Read

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit damage

07/11/02 (FS)

5.0	QC5	SECOND CHECK
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Comment: SECOND CHECK

Inspect level 5

07/11/02 (BS)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Welding*

W 07/11/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (D) Date: 07/11/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34829

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



85

Comment: FINAL INSPECTION/W/O RELEASE

09/11/06

Job Completion



09/11/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

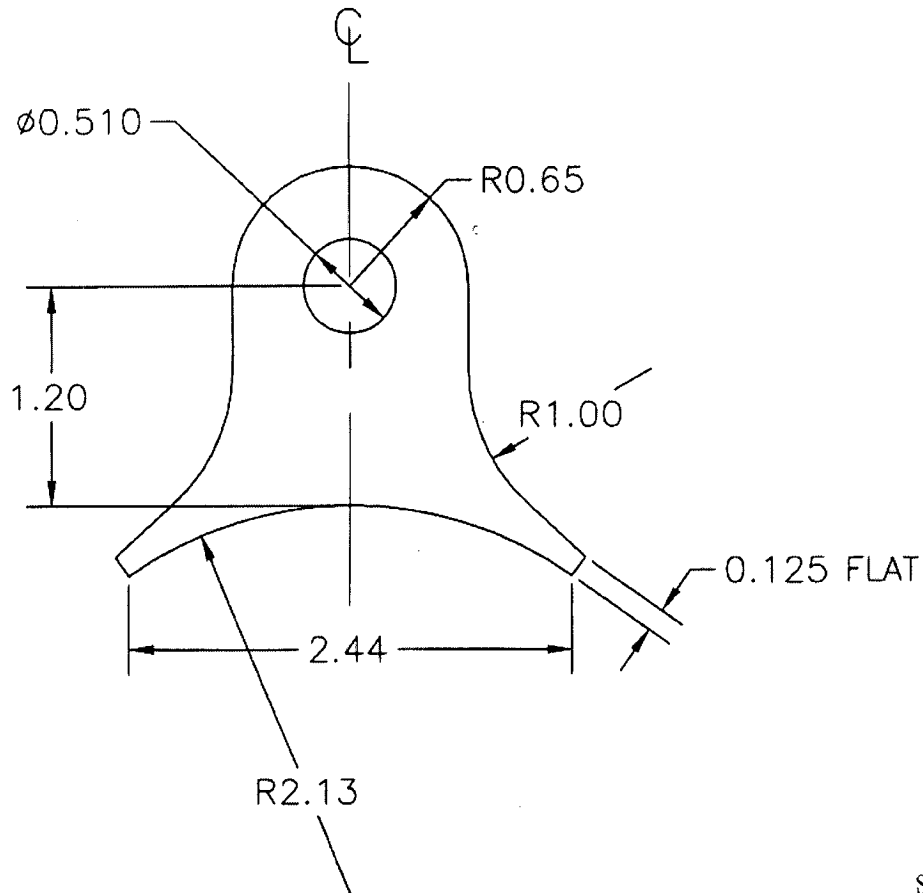
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT *	

RELEASED
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 34829

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

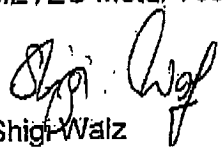
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
85	D2591	Lug B34829	4830
17	D2591	Lug B33568	4830

MATERIAL: supplied by DART M1010B07540X02500 B105801

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, November 2, 2007



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (513) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 16227**Date:** Nov 02, 2007**Page:** 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4830	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Oct 31, 2007

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2591 Lug in steel B34829	Each	90	85	
D2591 Lug in steel B33568	Each	17	17	
Material supplied by DART M1010B07540X02500 B105801				
Please note that 5 pieces were scrapped during machining.				
Received by _____		Thank you for your order!		